

Date: Friday, 01/08/2008 3:32:42 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLEEVE  
 Job Number : 40981  
 Estimate Number : 13330  
 P.O. Number :  
 This Issue : 01/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D37861  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3786 REVA  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 21/08/2008 Qty: 30 Um: Each  
 Previous Run : 40318  
 Written By :  
 Checked & Approved By : JD 08.8.05  
 Comment : Est Rev:A 08-05-20 new issue DD verified by:EC  
 Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T1000W065 6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 0.1750 f(s)/Unit Total : 5.2511 f(s)

6061T6 TUBE

batch: 108819

PR 08/08/05

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: DOOSAN LATHE

1- Turn as per Folio FA747 Rev: 1 & Dwg D3786 Rev: 1

2-Deburr per dwg D3786

20 08/08/05

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

PR 08/08/06

(30)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SP 08/08/06

(30)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

2/12/11

08/08/11

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:42 PM  
Use: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLEEVE

Job Number: 40981

Part Number: D37861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



30x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/08/11

7.0

PACKAGING 1

PACKAGING RESOURCE #1



50x30

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8/8/11

8.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/08/12

Job Completion



MF 08-08-11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

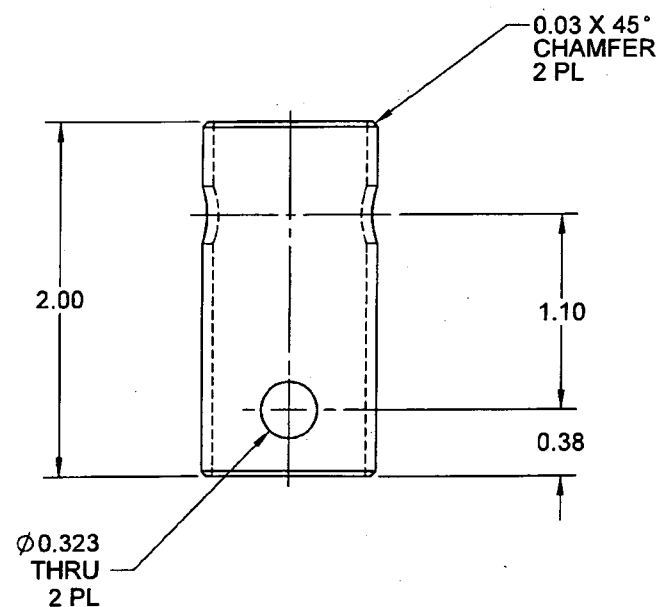
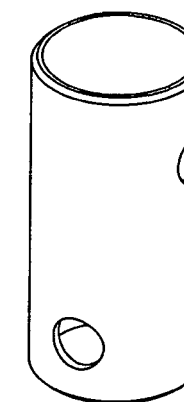
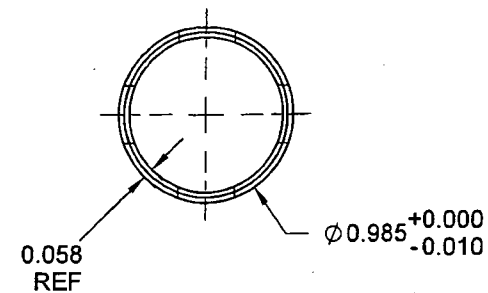
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# **D3786-1 SLEEVE**

## **NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

**RELEASED**  
08.06.04

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4098

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3786	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SLEEVE	NTS
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